

Split

Work Order ID 83467-1

83467

Page 1

April-18-12 2:39:00 PM

Item ID: D3137-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 18/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLT

Date: 12/04/18 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

OK 12/04/29

12

Jeaspa Bandsaw

Cut blanks: (.500" x 2.000") 5.570" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

12

12/04/11

HAAS CNC vertical machine #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-72-Deburr3-Scribe batch number

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

12

12/04/11

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83467

April-18-12 2:39:00 PM

83467

Page 2

Item ID: D3137-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 18/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

2L 12-06-11

130

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

9x

EP
12/06/19

Small Fab

Assemble D3137-043 as per Dwg D3137

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

8/2/06/19

(+9)

Quality Control

W/O:		WORK ORDER CHANGES					
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N900040100

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Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 235B

0.00

160

Packaging

Memo

0.00

9

12/06/20 JB

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/6/20 *[Signature]*

ME
12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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April-18-12 2:39:04 PM

Page 1

83467

D3137-043

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A04.02.18New issueKJ/DS

IPPP Rev B 08.07.03 ECN1207 EC verified by DID

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101		Purchased	No			100	Each	13.0000	1	8			
MS24694-S101									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST290A		13							
					120498	13							
D3137-3		Manufactured	No			140	Each	30.0000	1	8			
D3137-3									**				
Guide													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235A		30							
					76873	1							
					79735	29							
D3137-5		Manufactured	No			140	Each	6.0000	1	8			
D3137-5									**				
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235A		6							
					46740	3							
					77022	3							

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-18-12 2:39:04 PM

Page 2

Work Order ID: 83467

83467

Parent Item: D3137-043

D3137-043

Parent Item Name: Bracket Assembly

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 8.00

Required Qty: 8.00

M174B0.500X02.000

Purchased

No

140

f

40.3271

0.4643

3.909895

M174B0 500X02 000

**

17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT050

40.3271

100843

8.012

103089

13

14932

17.9051

19572

1.41

5.9 OK 12/04/29

April-18-12 2:39:04 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83467
Description:		Part Number: D337-7
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.900	+/- .030	1.890	✓		SLO8	Vern
.77	+/- .030	.770	✓		↓	
.56	+/- .030	.560	✓		↓	
Ø .560	+/- .010	Ø .563	✓		↓	
.950	+/- .010	.9445	✓		Height Gauge	
1/4-28 NF	—	1/4-28	✓		Thread gauge	
.262	+/- .010	.260	✓		Height gauge	
.062	+/- .010	.063	✓		"	
R.062	+/- .010	R.062	✓		Rad gauge	
4.850	+/- .010	4.8515	✓		SLO8	
.162	+/- .010	.162	✓		↓	
Ø .500	+/- .010	Ø .504	✓		↓	
1.880	+/- .010	1.880	✓		Height gauge	
2.360	+/- .010	2.360	✓		↓	
.318	+/- .010	.3145	✓		↓	
.833	+/- .010	.833	✓		↓	
R.250 R.250	+/- .010	R.250	✓		Rad gauge	
.200	+/- .010	.203	✓		SLO8	
.235	+/- .010	.229	✓		↓	
.076	+/- .010	.079	✓		↓	
.032	+0.0/- .010	.028	✓		↓	

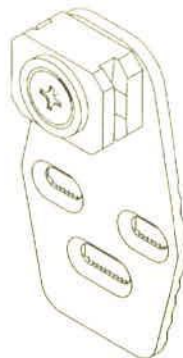
Measured by: *SL*
Date: 12/06/08

Audited by: *SL*
Date: 12-06-11

Preliminary Approval: _____
Date: _____

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

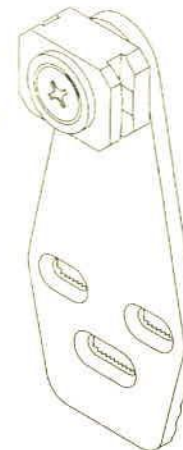
10.04.15



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83467 *MLJ*
12/04/10

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48. ZONE A 4 0.480 DIM WAS 0.605. ZONE A 9 0.67 DIM WAS 0.73. ZONE B 5 4.850 DIM WAS 4.975 & ZONE B8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR		AJS	08 05 30
E	ADD -.045		RF	05 11 23
D	RE-DESIGN D3137-5; CHANGE DIMS		DS	04 11 03
C	ADD -.043		DS	03 08 16
B	ADD RIDGES; ADD MATERIAL PROP		DS	03 01 16
A	NEW ISSUE		DS	02 04 17
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV F	
MFG APPR		D3137	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		BRACKET ASSEMBLY	NTS	
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMPILED OR CONVEYED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

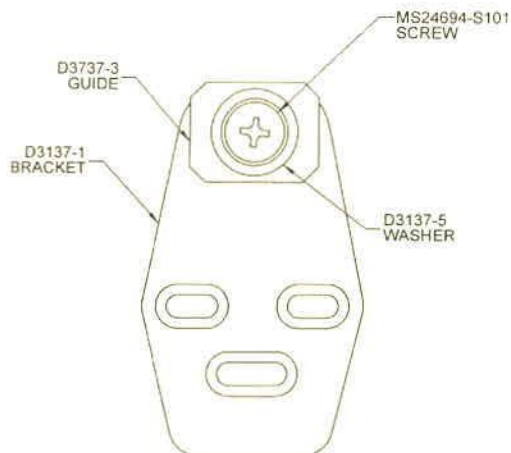
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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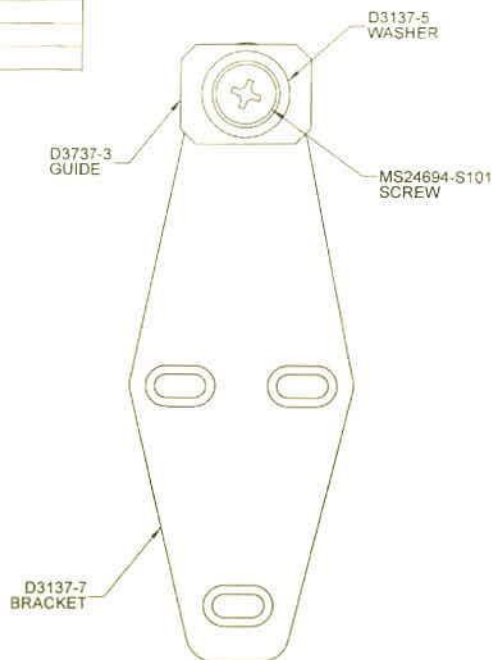
NOTE: Date & initial all entries

83467

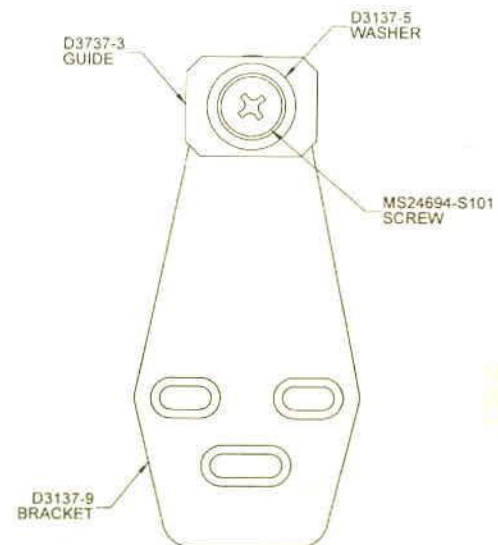
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
0.32 lbs -043
0.27 lbs -045

RELEASED
08.04.26/18

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3137	REV. F
MFG. APPR		TITLE BRACKET ASSEMBLY	SHEET 2 OF 5
APPROVED		SCALE NTS	
DE APPR		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.05.30		

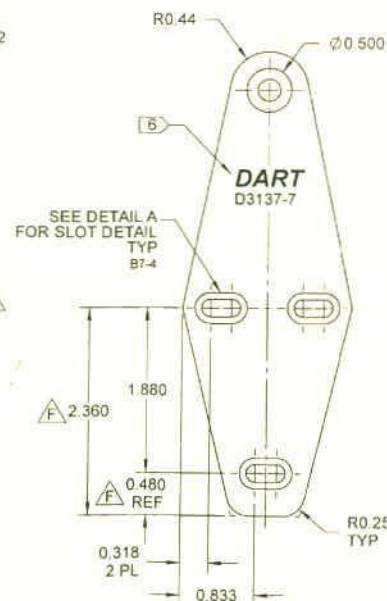
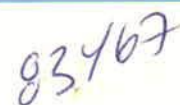
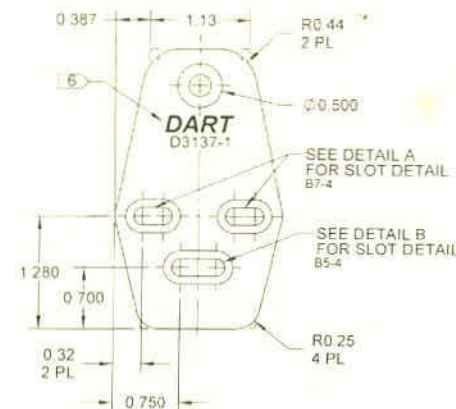
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING 15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
 - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
 - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
 - 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

HEET 2
51-108
RELEASE
08 06 24 WMD

DESIGN	DS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		REV. F SHEET 3 OF 5	
CHECKED			SCALE NTS	
MFG APPR			TITLE BRACKET ASSEMBLY	
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DE APPR				
DATE	08.05.30			

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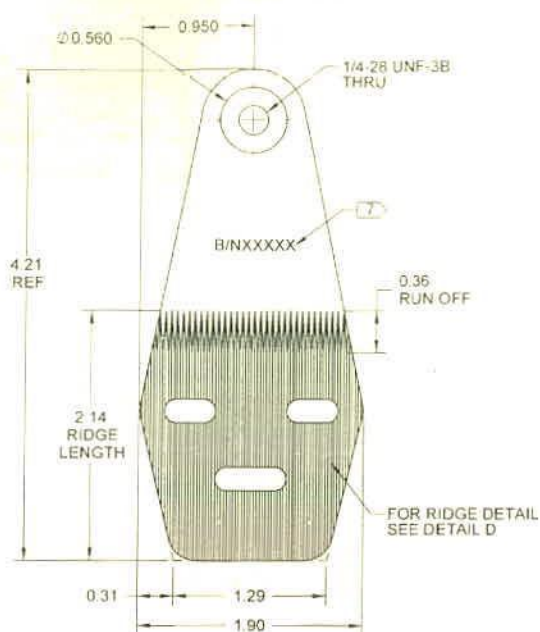
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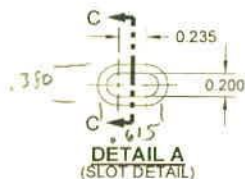
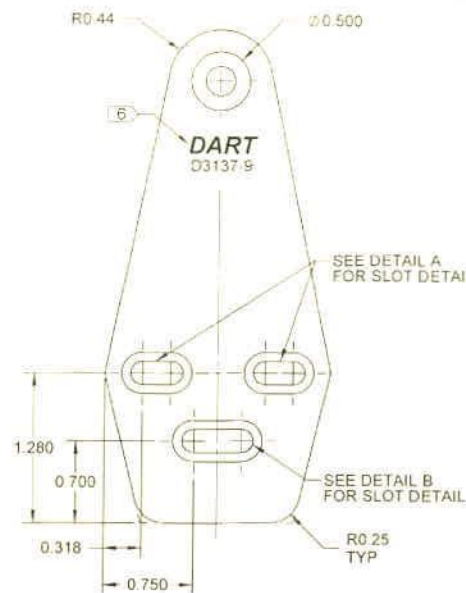
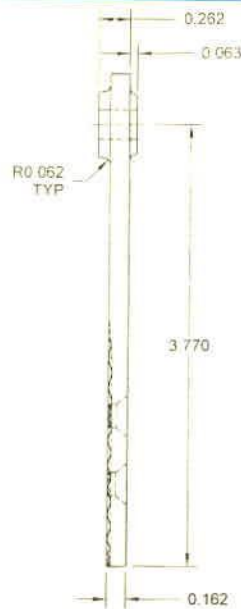
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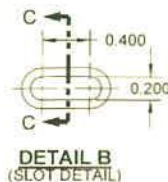
03467



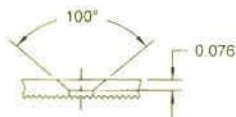
D3137-9 BRACKET



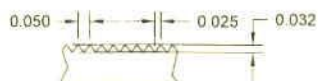
DETAIL A
(SLOT DETAIL)



DETAIL B
(SLOT DETAIL)



SECTION C-C
(SLOT DETAIL)



DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING 15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO D3137	REV. F
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		BRACKET ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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RELEASED

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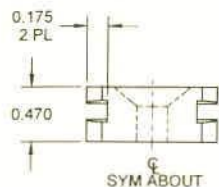
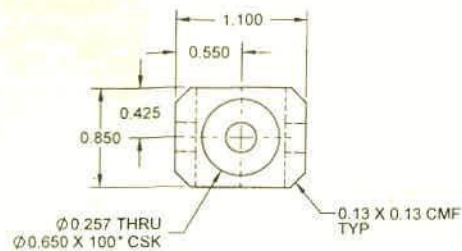
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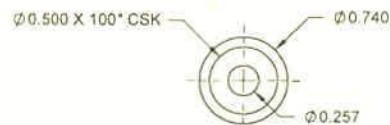
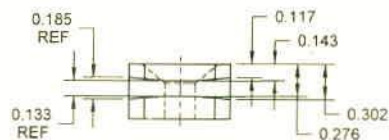
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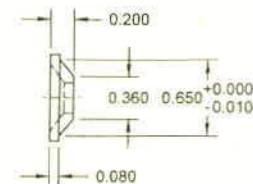
03467



D3137-3 GUIDE



D3137-5 WASHER



NOTES

- 1) MATERIAL: -3
DELTRIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELTRIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	JAJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries